

*Date: Thursday, 20/11/2008 3:35:12 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PEDAL ARM
Job Number : 43619	
Estimate Number : 10868	
P.O. Number :	Part Number : D32061
This Issue : 20/11/2008 S.O. No. :	Drawing Number : D3206 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : 36535	Material :
Written By :	Due Date : 21/12/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JUD 08.11.21</u>	
Comment : Est. A 04.04.15 New issue KJ/RF	
Est Rev:B Now On Waterjet 06-12-13 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NS125	4130 Sheet .125 (11GA)
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Comment: Qty.: 0.1848 sf(s)/Unit Total : 0.7392 sf(s)

4130 Sheet .125 (11GA)

Batch: 103505 1B 8-12-15

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3206

Dwg Rev: A

Prog Rev: A

1B 8-12-15

6

2-Deburr if necessary

1B 8-12-15

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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1B 8-12-15



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5 08/12/15 (x6)

5.0	POWDER COATING	POWDER COATING
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M 109648



6x

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

1:50
320°F

M-1 08/12/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:35:12 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ARM

Job Number: 43619

Part Number: D32061

Job Number:



Seq. #:

Machine Or Operation:

Description:

FINISH TIME:

2-20

M-1 08/12/15

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fx 08/12/15 (6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST200

JS 08/12/16 x6

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/16 JG

Job Completion



U 08/12/16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

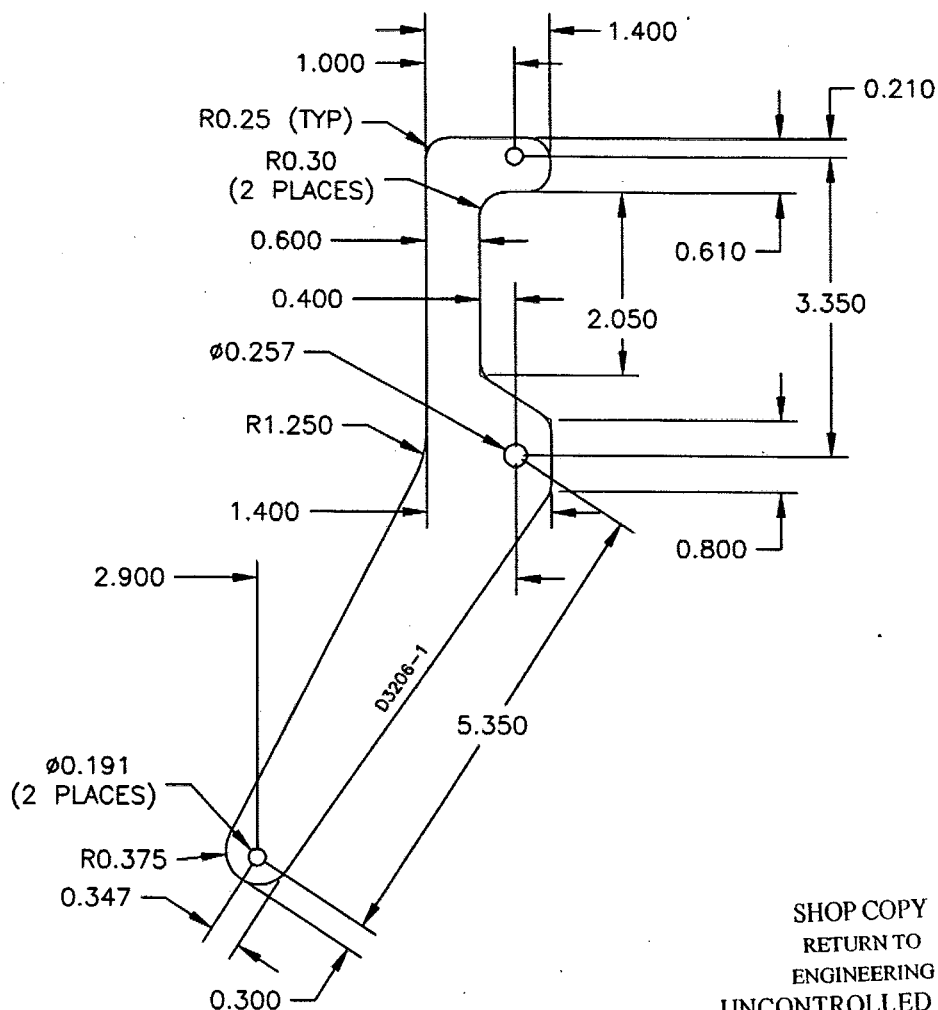
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3206	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE PEDAL ARM	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05



NOTES:

- 1) BREAK ALL UNMARKED SHARP CORNERS 0.005 TO 0.010
- 2) MATERIAL: AISI 4130N SHEET, 11 GAUGE (M4130N-S125)
- 3) FINISH POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N AS SHOWN
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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